

ASAP

Date: Friday, 23/11/2007 7:43:05 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING ANGLE		
Job Number	: 35969					
Estimate Number	: 10415					
P.O. Number	: N/A		Part Number	: D2417		
This Issue	: 23/11/2007 S.O. No. : N/A		Drawing Number	: D2417 REV. B		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B		
Previous Run	: 26908		Material	: N/A		
Written By	:		Due Date	: 30/11/2007 Qty: 20 Um: Each		
Checked & Approved By	:					
Comment	: Est:C 03.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF Est Rev:D Now on WaterJet 06-05-18 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
		 Comment: Qty.: 0.0411 sf(s)/Unit Total : 0.8211 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Batch: <u>M101022 RB 07-11-26</u> Identify for D2417
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D2417 Dwg Rev: <u>B</u> <u>RB 07-11-26</u> Prog Rev: <u>B</u>
		 <u>RB 07-11-26</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <u>RB 07-11-26</u> Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 <u>RB 07-11-26</u> Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <u>RB 07-11-26</u> Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 09/11/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/11/2007 7:43:05 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 35969

Part Number: D2417

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2416

SB

07/11/27

(20)

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr hole

INSPECT WORK TO CURRENT STEP

07/11/26/20

S 07/11/27 *x20* *coats*

8.0 QC5



Comment: INSPECT WORK TO CURRENT STEP

9.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YJ 07-11-28

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

BL

07-11-28

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST32

K 07/11/28

12.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/28

Job Completion



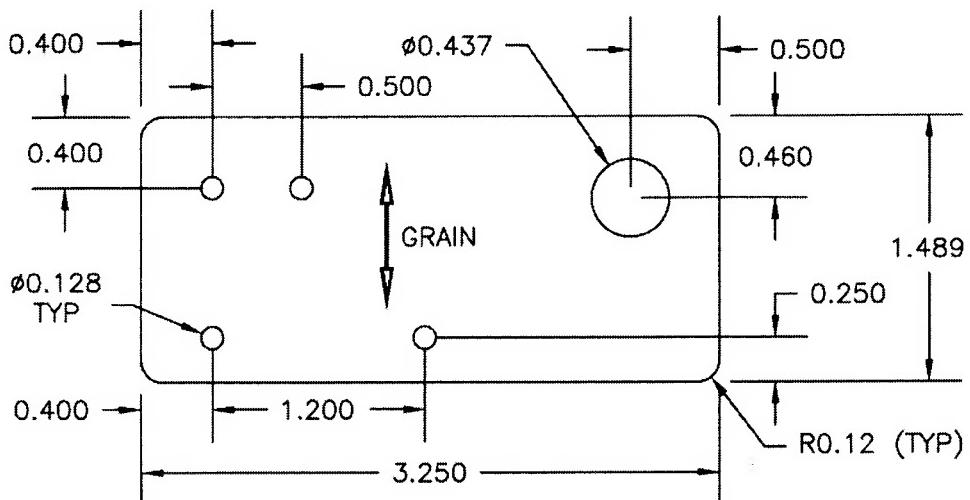
U 07/11/29



A circular stamp with the words "A COPY ISSUED" arranged in a circle.

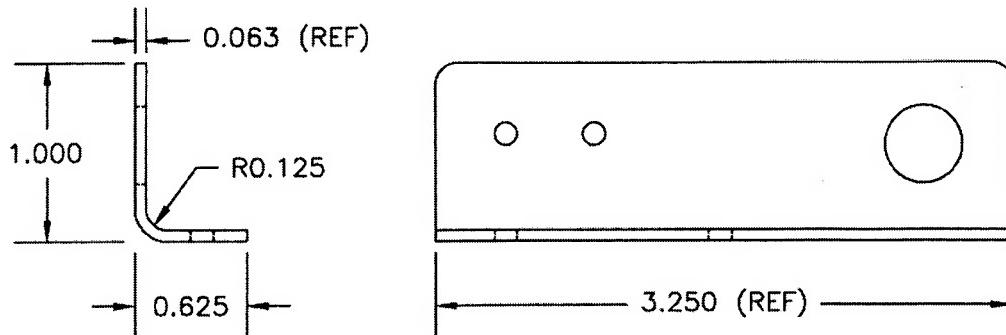
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>RF</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2417	REV. B	SHEET 1 OF 1
DATE 03.04.09		TITLE MOUNTING ANGLE	SCALE 1:1	
A	95.04.06	NEW ISSUE		
B	03.04.09	ADDED ϕ 0.128 & FLAT PATTERN		

RELEASED
03.05.01 #



FLAT PATTERN

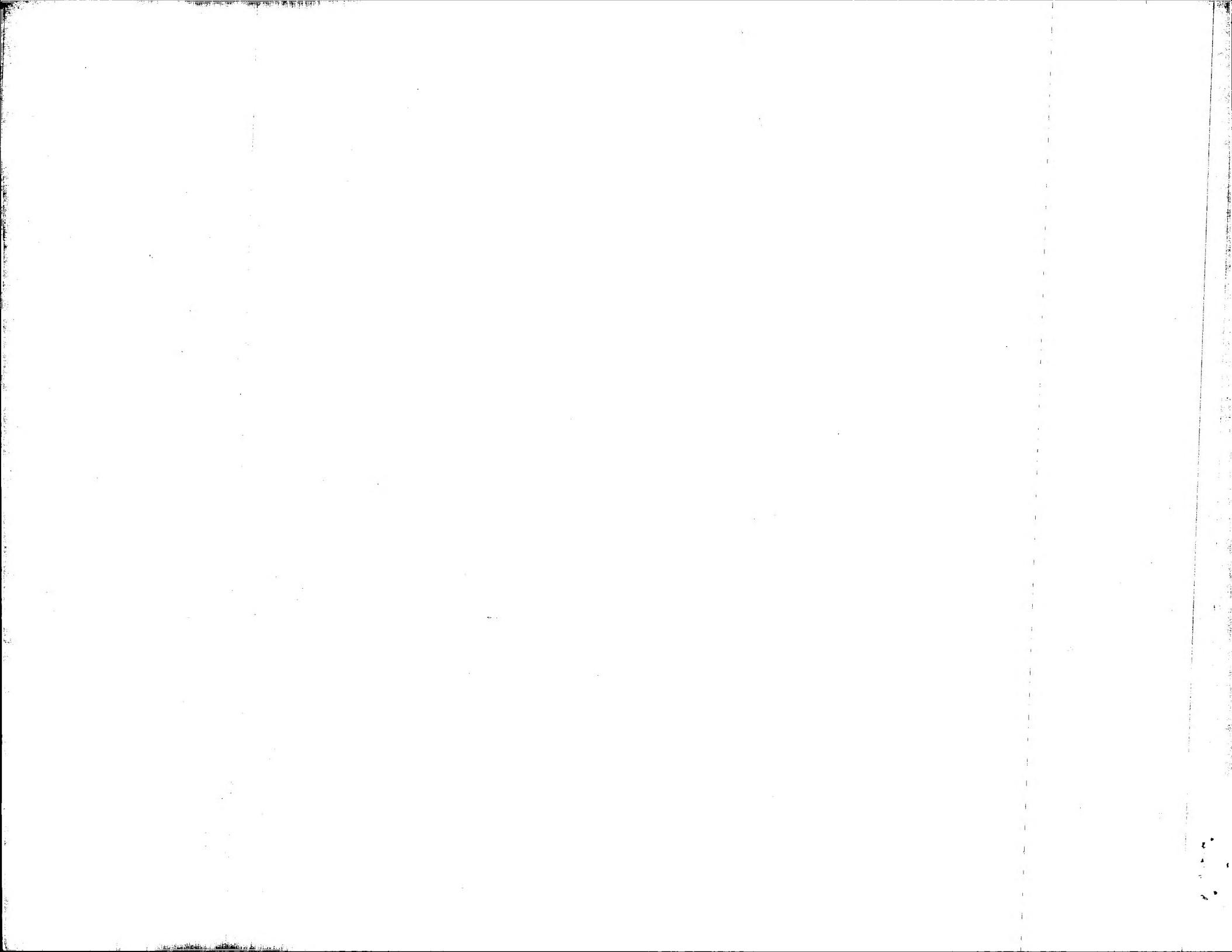
Wb 4
35969



BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3/T3511 0.063" THICK PER QQ-A-250/4 (REF DART SPEC: M2024T3S.063)
 - 2) FINISH: ACID ETCH AND ALODINE AS PER DART QSI 005 4.1
 - 3) DEBURR ALL SHARP EDGES 0.005 TO 0.010
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



DART AEROSPACE LTD	Work Order:	35969
Description: MOUNTING ANGLE	Part Number:	D2417
Inspection Dwg: D2417 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	RB	Audited by:	S	Prototype Approval:	<input checked="" type="checkbox"/>
Date:	07-11-26	Date:	07/14/26	Date:	07/14/26

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	